Ship Wed 26/03 Rev 8 DAS 16 9-89 14/03/26

Work Order ID 115293

March-24-14 12:55:29 PM

115293

~~PRELIMINARY ISSUE~~

Item ID: D4541-6 D4541-6 B115293

Revision ID:

Item Name: Bracket,RH

Start Date: 3/24/14 **Start Qty:** 10.00 *10*

Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*

Reference:

Accept *N900040100* **Setup Start** *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____

QC: _____ **Date:** _____

Tooling: _____ **Date:** _____

SPC (Y/N): _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4541	**Revision Nbr** D Rev E DAS 27 9-89								
100		0.00							
100									
Waterjet	**Memo**	0.00				10	0		JM14-03-25
FLOW CNC Waterjet	1- Cut as per dwg (CUT D4541-5F) Prog rev: D4541 Dwg rev: D Rev E DAS 10 9-89								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	**Memo**	0.00				10	0		JM14-03-25
Quality Control									

Work Order ID 115293

March-24-14 12:55:29 PM

115293

Item ID: D4541-6
Revision ID:
Item Name: Bracket,RH
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 9-89 14/3/25				10			
120 QC Quality Control	**Memo**	0.00				Inspect as per DWG PE2			
125		0.00		DAS 30 9-89		10			14/03/25
125 Small Fab Small Fab	**Memo** BEND TABS PER DWG	0.00							
127	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
127 QC Quality Control	**Memo**	0.00				(10) 14-03-26			

Work Order ID 115293

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115293

Item ID: D4541-6
Revision ID:
Item Name: Bracket,RH
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				10	14-3-26		
130									
HandFinish	**Memo**	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00 DAS 27 9-89 14/3/26				10			
140									
QC	**Memo**	0.00							
Quality Control						Inspect as per Dwg PEQ			
150	Identify as per dwg & Stock Location ST 525	0.00				8			
150						DAS 28 9-89			MAR 26 2014
Packaging	**Memo**	0.00							
Packaging									

Work Order ID 115293

March-24-14 12:55:29 PM

115293

Item ID: D4541-6
Revision ID:
Item Name: Bracket,RH
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MLJ 14-03-26

MLJ 14-03-26

POSITIVE RECALL
EFFECTIVE 4-3-24 AUTH LL
RELEASED 16 9-89 DATE 14/03/26

Release Dwg Rev E DAS 27 9-89 Rev 14/3/26

Picklist Print

March-24-14 12:55:28 PM

Work Order ID: 115293 *115293*

Parent Item: D4541-6 *D4541-6*

Parent Item Name: Bracket,RH

Start Date: 3/24/14 **Required Date:** 3/25/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 12.05.08 as per dwg revC DD verf:EC IPP
REV:B 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	379.2832	0.3606	4			
M6061T6S.032									**			JM 14-03-25	
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code	
MAT021	379.28317		
123483	8.57		
m125822	17		
m127272	119.43317		
m128054	234.28		128054

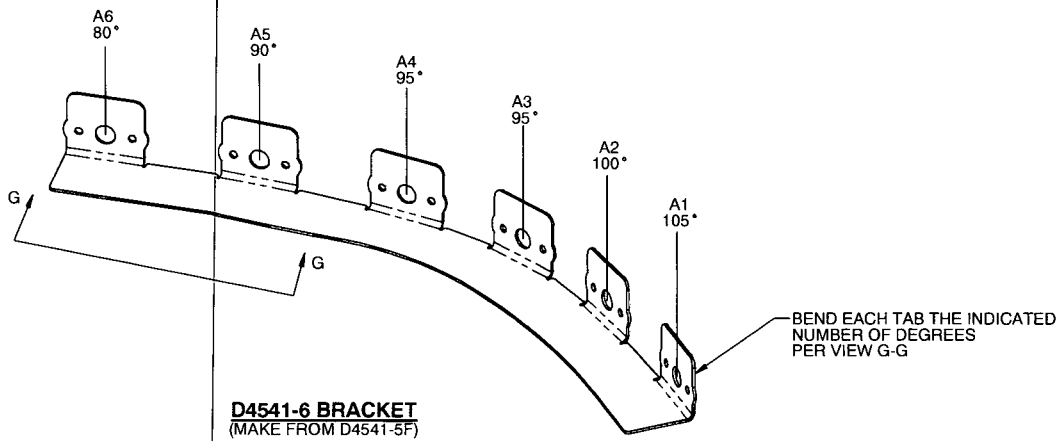
DART AEROSPACE LTD	Work Order:	115293
Description: Bracket	Part Number:	D4541-6
Inspection Dwg: D4541 **Rev:** D/E2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

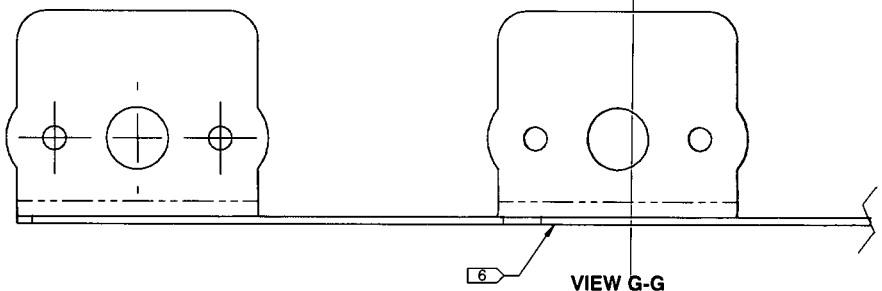
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	—		V	JKm05
Ø0.257	+0.006/-0.001	0.258"	—		V	
0.688	+/-0.010	0.690"	—		V	
0.344	+/-0.010	0346"	—		V	
1.00	+/-0.030	1.005"	—		V	
0.320	+/-0.010	0.320"	—		V	
~~1.55~~ 1.75"	+/-0.030	1.754"	—		V	
~~5.3~~ 5.4"	+/-0.100	5.4"	—		V	JKm08
9.8	+/-0.100	9.8"	—		V	
0.032	+/-0.010	0.031"	—		V	
			DAS			

Measured by:	Jm	Audited by:	27 9-89	Preliminary Approval:	
Date:	14-03-25	Date:	14/3/25	Date:	

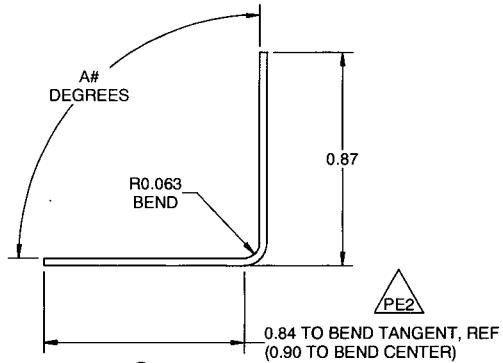
Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.05.08	Dwg Rev updated	KJ	



D4541-6 BRACKET
(MAKE FROM D4541-5F)



VIEW G-G
BEND DETAIL
SCALE 2X



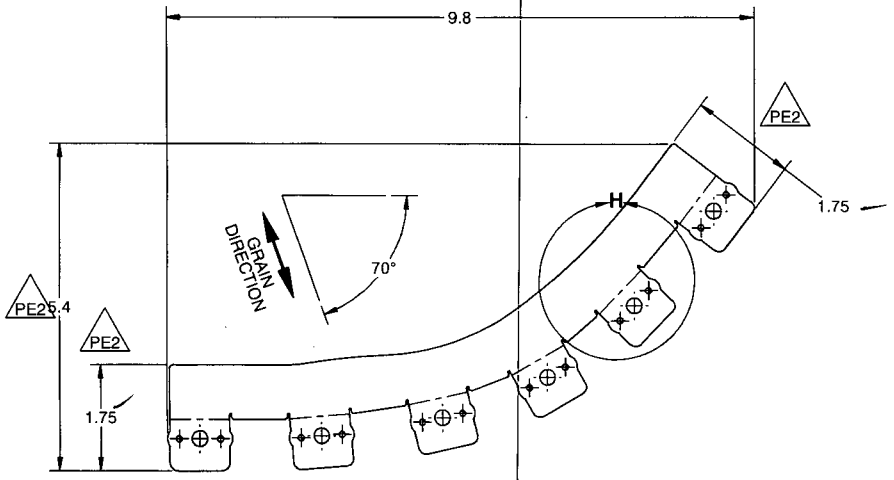
PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: MAKE FROM D4541-5F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

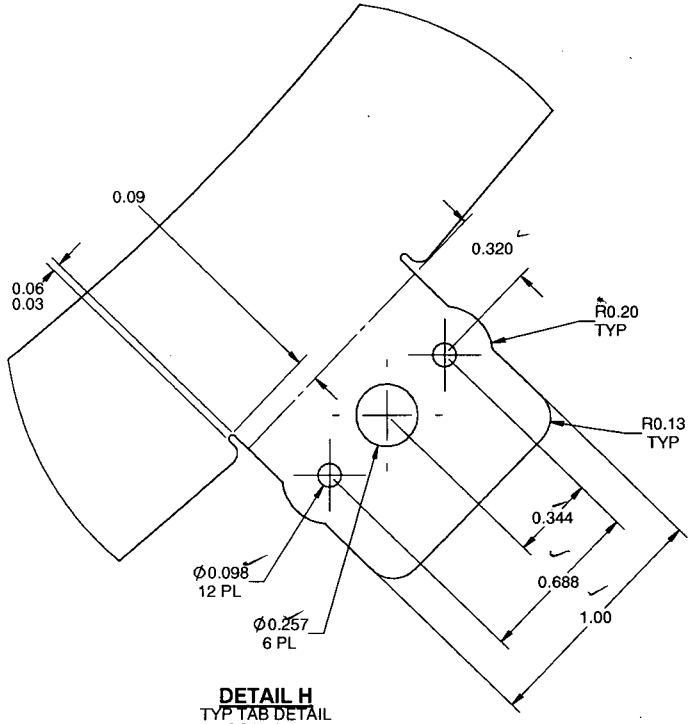
Wb 115293

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 REV. PE2
MFG. APPR.		SHEET 9 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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D4541-5F FLAT PATTERN



DETAIL H
TYP TAB DETAIL
SCALE 4X

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.04 lbs
8) PROFILE PER DRAWING FILE "D4541-5F-REVE.DXF"

PRELIMINARY E2
14.03.07 (AJS)

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 REV. PE2
MFG. APPR.		SHEET 10 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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DART AEROSPACE LTD

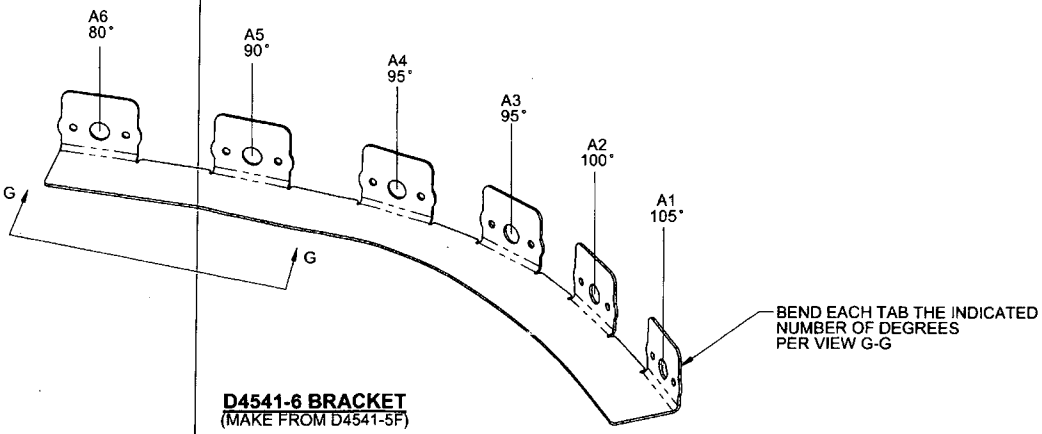
DART AEROSP

Description: Bracket RH		Work Order:	115293
Inspection Drawing: D4541	Rev: PE2	Part Number:	D4541-6

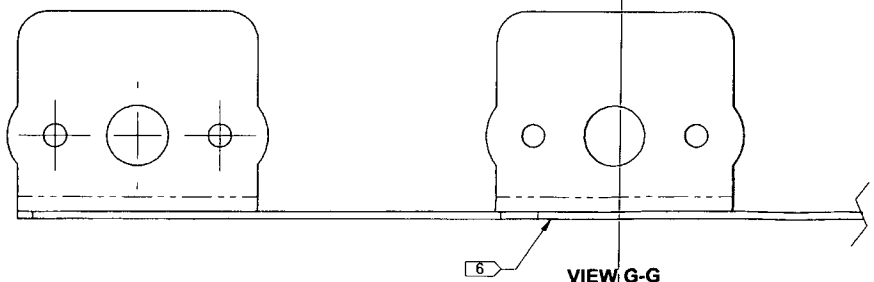
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.87	+/- .030	.878	✓		V	SN-11
.84	+/- .030	.845	✓		V	SN-11
80°	+/- ½°	80°	✓		Protractor	SN-7
90°	+/- ½°	90°	✓		"	SN-7
95°	+/- ½°	95°	✓		"	SN-7
100°	+/- ½°	100°	✓		"	SN-7
105°	+/- ½°	105°	✓		"	SN-7

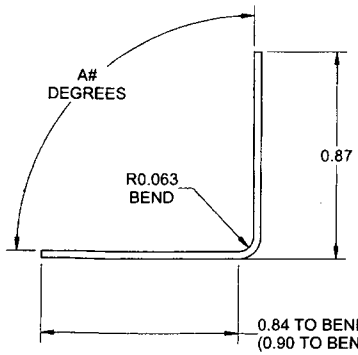
Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (if necessa		
Date 14/03/25	Date 14/03/25	Date 14/3/25	Date		



D4541-6 BRACKET
(MAKE FROM D4541-5F)



VIEW G-G
BEND DETAIL
SCALE 2X

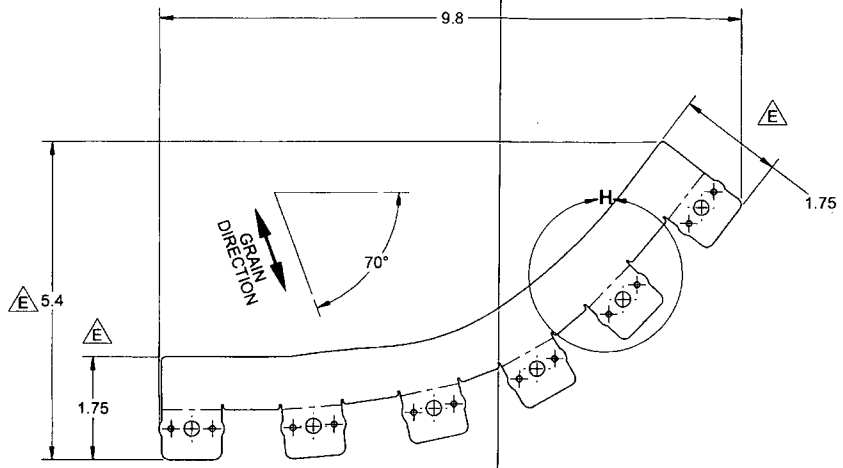


2014 -03- 26

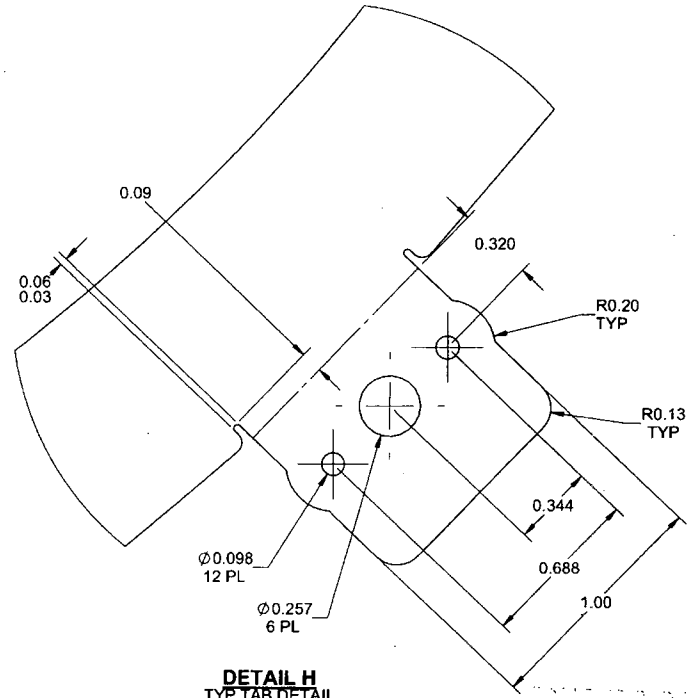
NOTES:
1) MATERIAL: MAKE FROM D4541-5F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4541	SHEET 9 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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D4541-5F FLAT PATTERN



DETAIL H
TYP TAB DETAIL
SCALE 4X

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.04 lbs
8) PROFILE PER DRAWING FILE "D4541-5F-REVE.DXF"

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4541	SHEET 10 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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